

Work Order ID 55107

January 06, 2010 11:24:11 AM

Page 1

Item ID: D3763-043

Accept

Setup Start

Revision ID:

Stop

Item Name: End Fitting Assembly, LH

Start Date: 1/6/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 1/11/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-01-06 Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3763	Rev B

100 Pick Kit 0.00



Packaging

Memo

0.00

Packaging

SP 10-01-06

110 Large Fab 0.00



Large Fab

Memo

0.00

Large Fab

1-make a 0.063" chamfer on D3763-1 fitting before ass'y! 12-assemble and tack weld as per dwg D3763 using locating pin DT9039 *****look at dwg before assembling parts (LH)***** *****remove pin before welding***** 13-weld as per dwg D3763 QSI004 Alum H 111385

SP 10-01-07

120 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

10 PD 10.01.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) S 10-01-8

110

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

BR 10-01-8

10

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10-01-8

210

W/O:		WORK ORDER CHANGES					
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Page 3

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Required Date: 1/11/2010 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location 251A

0.00



Packaging

Memo

0.00

Packaging

10-1-8

sf (10x)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/11

R 10-1-08 (10)

W/O:		WORK ORDER CHANGES					
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Picklist Print

January 06, 2010 11:24:11 AM

Page 1

Work Order ID: 55107

Parent Item: D3763-043

Parent Item Name: End Fitting Assembly, LH


Comments:

Start Date: 1/6/2010

Required Date: 1/11/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3763-1  End Fitting		Manufactured	No			110	Each	183.0000	20.0000			

SP ~~07~~ 10.01.06


Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	183
45891	2
54364	140
54433	41

✓ 2x
18x

D3763-5  Tube		Manufactured	No			110	Each	38.0000	10.0000			
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SP 10.01.06

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	38
42734	18
54380	20

✓ 10x

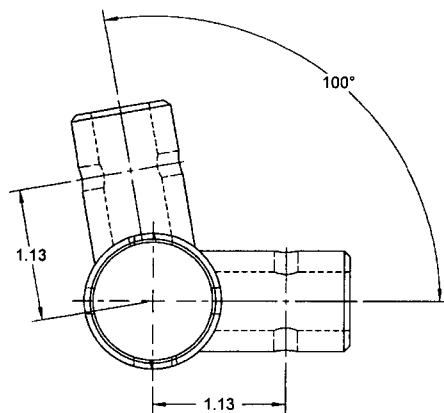
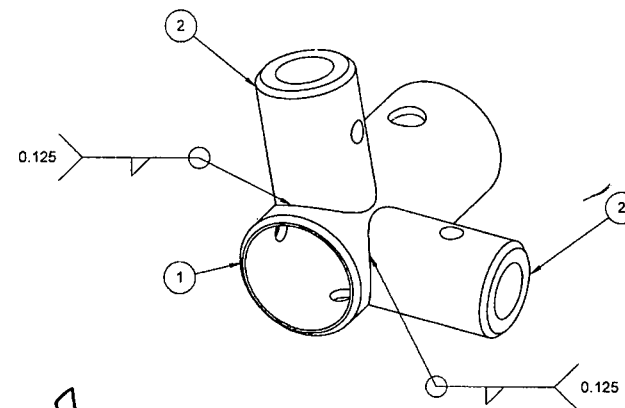
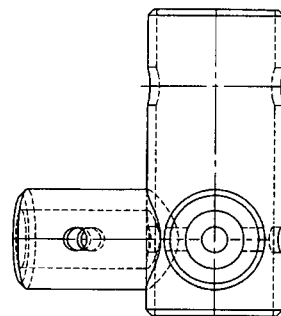
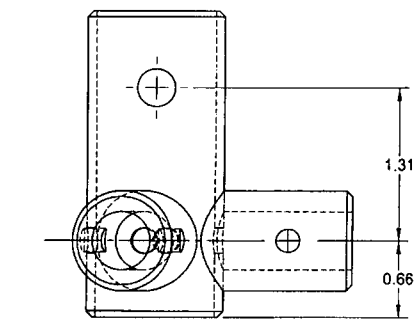
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#55107

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-5	TUBE	1
2	D3763-1	FITTING	2

D3763-043 END FITTING ASSY, LH

RELEASED
08-01-10/11

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs
- 8) WELD: PER DART QSI 004

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO. D3763	REV. B
MFG. APPR.	HS	TITLE END FITTING	SHEET 2 OF 9
APPROVED	HS	SCALE	NTS
DE APPR.	HS	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
DATE	08.06.23	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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